

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020131**Date Inspected:** 26-Dec-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC) Chanxing Island**Location:** Shanghai, China**CWI Name:** Mr. LIU HUA JIE**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment**Summary of Items Observed:**

On this date CALTRANS OSM Quality Assurance (QA) Inspector Santhosh Ramakrishna was present during the times noted above for observations relative to fabrication work of the Self Anchored Suspension (SAS) Superstructure being performed.

This QA inspector randomly observed the following work:

1. INPROCESS:

Orthotropic Box Girder (OBG) at Trial Assembly Area:

ZPMC welding personnel performing Shielded Metal Arc Welding (SMAW) of Base Metal Repair weld (temporary attachment removal area) near the side plate to side plate transverse splice weld joint located on 12AE+12BE at cross beam side. The location near the weld is designated as OBE12D-001. The welder is identified as 052910. ZPMC QC Mr. AN QING XING was onsite monitoring the welding variables. The inprocess SMAW appears to be progressing in compliance with WPS-345-SMAW-4G (4F)-FCM-Repair-1. The weld repair report number is named as CWR-2126.

ZPMC welding personnel performing Shielded Metal Arc Welding (SMAW) of Built-up weld in the floor beam plate temporary hope hole of 25mm radius located on CB-17. The part is designated as FB3058. The welder is identified as 040673. ZPMC QC Mr. LIU CHUAN GANG was onsite monitoring the welding variables. The inprocess SMAW appears to be progressing in compliance with WPS-345-SMAW-3G (3F)-Repair-1. The weld

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repair report number is named as CWR-2151.

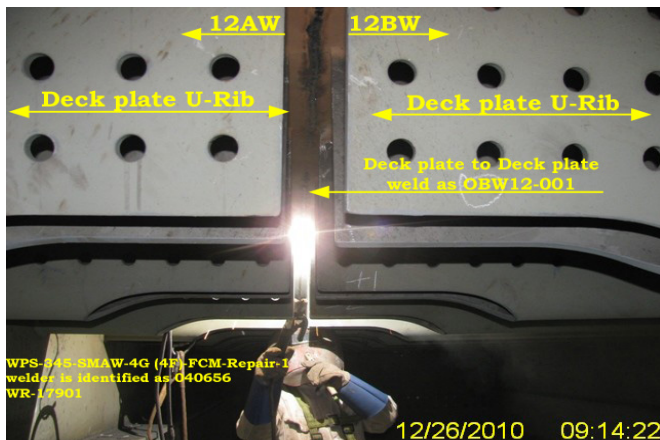
ZPMC welding personnel performing Shielded Metal Arc Welding (SMAW) of Repair weld for the bottom plate to side plate hold back weld joint located on 11EE+12AE at cross beam side. The weld is designated as SEG3001A-015. The welder is identified as 050289. ZPMC QC Mr. AN QING XING was onsite monitoring the welding variables. The inprocess SMAW appears to be progressing in compliance with WPS-345-SMAW-4G (4F)-FCM-Repair-1. The weld repair report number is named as CWR-2457.

ZPMC welding personnel performing Shielded Metal Arc Welding (SMAW) of Repair weld for the deck plate to deck plate transverse splice weld joint located on 12AW+12BW. The weld is designated as OBW12-001. The welder is identified as 040656. ZPMC QC Mr. ZHOU PENG was onsite monitoring the welding variables. The inprocess SMAW appears to be progressing in compliance with WPS-345-SMAW-4G (4F)-FCM-Repair-1. The weld repair report number is named as WR-17901. Further weld detail mention in attached picture.

ZPMC welding personnel performing Shielded Metal Arc Welding (SMAW) of Repair weld for the longitudinal diaphragm to floor beam hold back weld joint located on west side of 12AW at counter weight side. The weld is designated as SEG3004W-019. The welder is identified as 040611. ZPMC QC Mr. WANG ZHU was onsite monitoring the welding variables. The inprocess SMAW appears to be progressing in compliance with WPS-345-SMAW-3G (3F)-FCM-Repair-1. The weld repair report number is named as WR-19409.

ZPMC welding personnel performing Shielded Metal Arc Welding (SMAW) of Repair weld for the longitudinal diaphragm flange to floor beam hold back weld joint located on west side of 12AW at cross beam side. The weld is designated as SEG3004T-009. The welder is identified as 040611. ZPMC QC Mr. WANG ZHU was onsite monitoring the welding variables. The inprocess SMAW appears to be progressing in compliance with WPS-345-SMAW-1G (1F)-FCM-Repair-1. The weld repair report number is named as WR-19386.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



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Summary of Conversations:

No relevant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Pillai,Santosh	Quality Assurance Inspector
Reviewed By:	Miller,Mark	QA Reviewer
